

Date: Tuesday, 10/2/2007 10:44:01 AM  
 User: Kim Johnston

## Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 34943	
Estimate Number : 12712	
P.O. Number :	Part Number : D35371
This Issue : 10/2/2007 S.O. No. :	Drawing Number : D3537 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 34282	Material :
Written By :	Due Date : 10/30/2007 Qty: <u>125</u> Um: Each
Checked & Approved By : <u>10710.02</u>	
Comment : Est Rev: A New Issue 07-02-14 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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10.0076



Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)  
 M304S16GA .063" 304 SS SHEET  
 Batch: 105130 107-10-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3537  
 Dwg Rev: C 107-10-9  
 Prog Rev: C  
 2-Deburr if necessary 107-10-9

125

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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107-10-9



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

107-10-9 125

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.  
 2-Identify as D3537-1

107-10-9 125

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:44:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 34943

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

M105599/M106036 FC/28

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

07/10/26

125x

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-29

125

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters  
07/10/29

125

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105642



125

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/10/31

125X

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR17

1

BR

07-10-31

125

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31

Job Completion



07/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

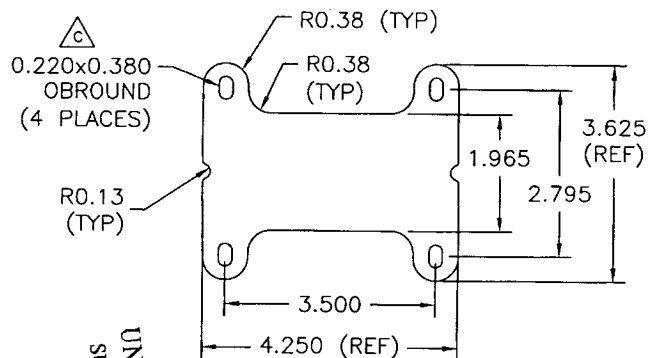
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

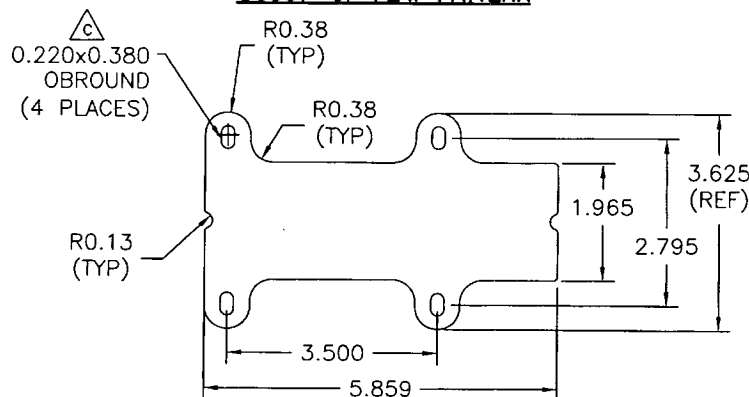
NOTE: Date & initial all entries



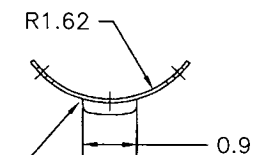
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

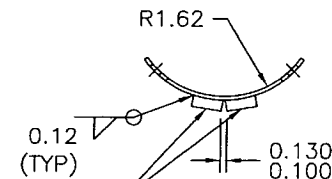


### SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

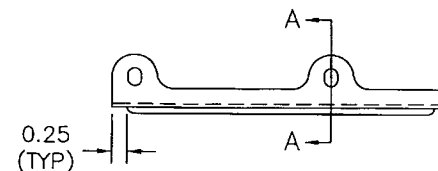
### SECTION B-B



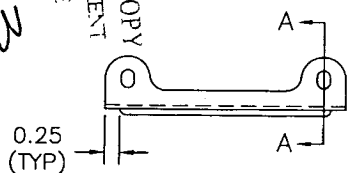
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

**RELEASED**  
07.05.08 AM  
PER ECU  
962

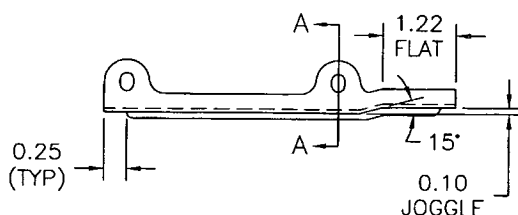
### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



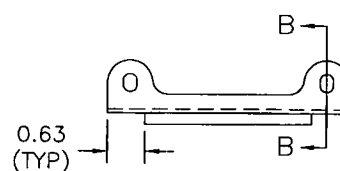
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

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